

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018027**Date Inspected:** 13-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT)

**OUTSIDE YARD**

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 12BW. The weld designation reviewed is as follows:

DP3054-001-015,016,018,019

SEG3005L-013,014

SEG3005J-002,003,004,005,014

SEG3005C-005

SEG3005H-014

During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Orthotropic Box Girder (OBG) segment 12BW, this Quality Assurance Inspector (QA) discovered the following issue:

-One (1) longitudinal linear indication measuring approximately 10mm in length.

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## WELDING INSPECTION REPORT

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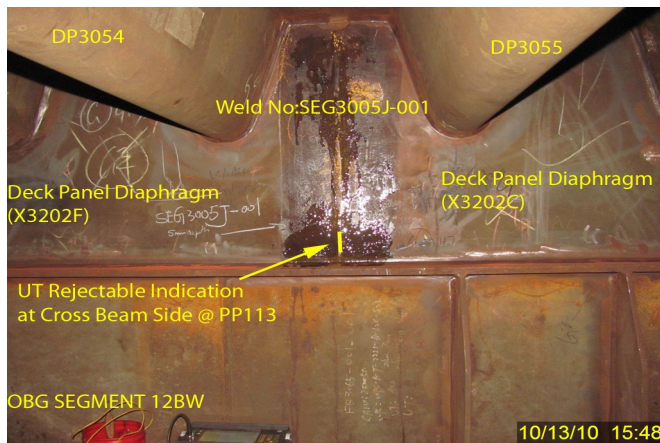
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- The indication dB rating is a +2.
- The Material thickness is 14mm.
- The depth of the indication is approximately 6mm.
- The Y distance for this indication is 650 mm from top Cope hole.
- The weld is identified as SEG3005J-001 at Cross Beam Side, Panel Point PP113.
- This weld is Butt weld joining between Deck Panel Diaphragm (X3202F) to Deck Panel Diaphragm (X3202C).
- This weld joint is designated as Non-Seismic performance critical (Non-SPCM).
- The indication is clearly marked on or near the weld.
- The Segment 12BW is located at near trial assembly Yard.

The Notice of Witness Inspection (NWIT) No. is 006916. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

This Quality Assurance (QA) Inspector wrote an Incident Report for above mentioned discrepancy observed in OBG Segment 12BW and prior to issue it was informed to ZPMC QC and ABF QA. Please reference the Incident Report # 04-0120F4\_TL-15\_B286\_10-13-10\_12BW\_UT Indication. For further information, please see the attached picture below.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai, Pandaram

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer